

156987

Wednesday, February 08, 2017 10:19:09 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

10

10

Customer:

Reference:

FEB 14 2017

Tooling:

Date:

Run Start *NR1*

SPC (Y/N):

Date:

Stop *NR2*

Draw Nbr	Revision Nbr
D4151	C

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D4151

Prog Rev: C

Dwg Rev: C

Deburr as required

0.07

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By 		
							Lead hand / Supervisor Approval Verification 		
							QC / QA Coordinator Approval 		

Root Cause				FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence		
☐ OTHER : _____							

Work Order ID 156987

Wednesday, February 08, 2017 10:19:09 AM

156987

Page 2

Item ID: D4151-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Hardpoint Plate
Start Date: 2/14/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 2/16/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						10			DAS 38 9-89
QC	Memo	0.03							
Quality Control									FEB 21 2017
150	Identify as per dwg & Stock Location: STORE	0.00							
150						10			DAS 6 9-89
Packaging	Memo	0.02							FEB 11 2017
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.17							
Quality Control									17/2/23 MF 17-2-22

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Wednesday, February 08, 2017 10:19:08 AM

Page 1

Work Order ID: 156987

156987

Parent Item: D4151-3

D4151-3

Parent Item Name: Upper Hardpoint Plate

Start Date: 2/14/2017

Required Date: 2/16/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased		No		100	sf	62.4100	0.055	0.578947			

M304S11GA

304/316 0.125 Sheet

02/17/2017

Location

Loc Qty

Loc Code

MAT020

62.40998

M129545

0.00109

M134604

1.3

M135355

2.80889

M136327

26.3

M136687

32

- 6

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				



NO. 156987 MJS
1702-14

RELEASE
2011-01-18
MD

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
7) WEIGHT:
- D4151-1 = 0.24 lbs
- D4151-3 = 0.23 lbs

DESIGN			DART AEROSPACE LTD	
DRAWN			HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV. 1
MFG. APPR.			D4151	SHEET 2 OF 2
APPROVED			TITLE	SCALE
DE APPR.			BASKET FWD HARDPOINT	
DATE	10.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PREPARED AND CONTAINS CONFIDENTIAL INFORMATION THE USE OF WHICH IS NOT TO BE USED FOR ANY PURPOSE OR ON ANY MEDIUM WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.		